

Work Order ID 131155

Wednesday, April 08, 2015 11:03:09 AM

131155

Page 1

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 3/26/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/26/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								

100

100

Skidtubes

Skidtubes

Skidtubes

Memo

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

0.00

0.04

10 15-4-8 [Signature]

120

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.02

10 15-4-9 [Signature]

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-99
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10	0	15-04-10		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG</u> Memo	0.00 0.00				10	0	15-04-10	BE	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02				ML5		15-04-10		

(Signature) 15-4-10

Picklist Print

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Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 3/26/2015

Required Date: 3/26/2015

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

Each

98.0000

10

D2600-5-108

15-4-8
[Signature]

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

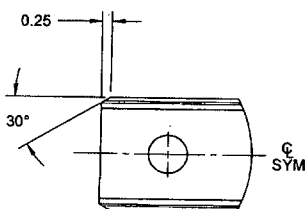
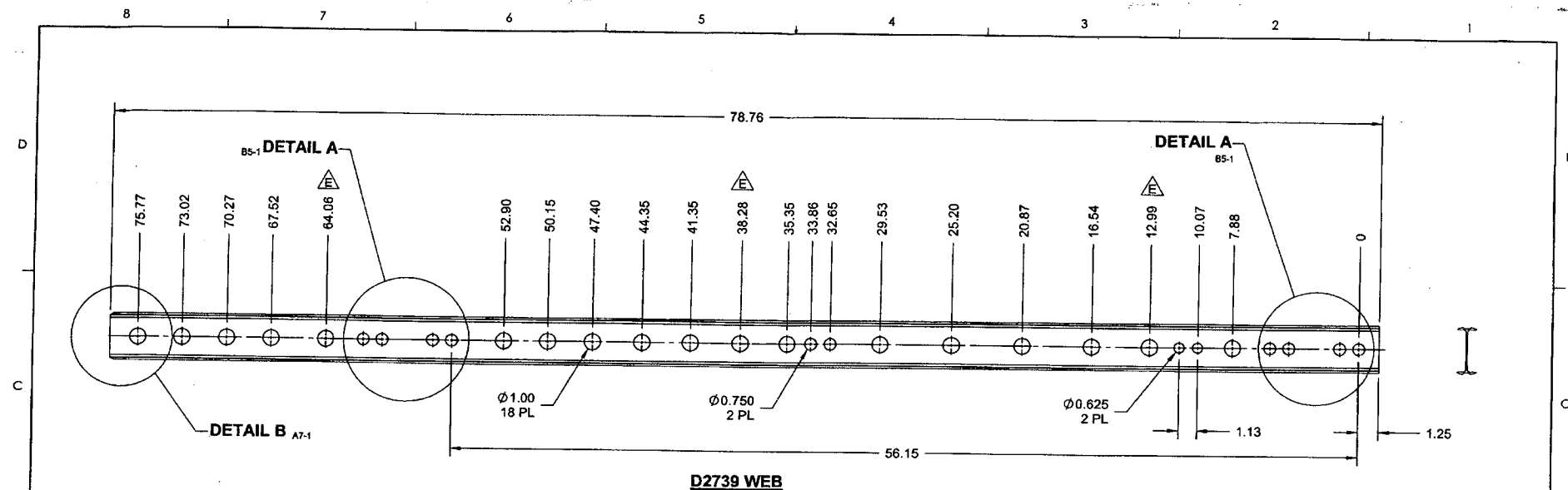
HALL

98

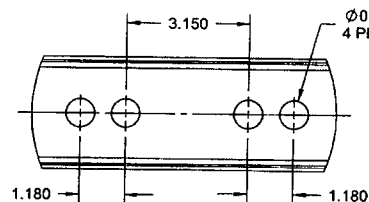
112593

98

10



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

DESIGN	DS	DESCRIPTION	BY	DATE
DRAWN	GP	DART AEROSPACE USA, INC.		
CHECKED	AP	PORT HADLOCK, WA		
MFG. APPR.	AP	D2739	REV. E	
APPROVED	AP	WEB	SHEET 1 OF 1	
DE APPR.	AP		SCALE	
DATE	10.10.08		NTS	